Work Order ID 115778 **●**115778**●** Page 1 April-04-14 10:21:31 AM *N900040100* Setup Start Accept Item ID: D3403-5 **Revision ID:** Stop Item Name: Bushing *58* **Start Oty: 58.00 Cust Item ID: Start Date:** 4/04/14 Reg'd Otv: 58.00 Required Date: 4/04/14 **Customer:** *58* Reference: Run Date: 14-04-09 Tooling: Process Plan: ________ Date: Approvals: Stop Date: SPC (Y/N): Date: Reject Reject Tool ID Tool # Plan Accept Insp. Set Up/ Sequence ID/ Operation Code Oty Oty Number Stamp Work Center ID Description **Run Hours** Draw Nbr **Revision Nbr** D3403 D DAS 0.00 100 Hardinge CNC LATHE SMALL *100* 0.00 Hardinge Memo 1- Turn as per Folio FA925 & Dwg D3403 Hardinge CNC Lathe Small Folio Rev: Dwg Rev: 🕥 2-Deburr QC2- Inspect parts off machine FAI/FAIB 0.00 110 60 *110* 0.00 OC Memo Quality Control + DAS

120

120

Quality Control

QC

Memo

QC8- Inspect parts - second check

0.00

0.00

60 8

25. 3

DQA:		Date:			_							
					WORK ORDER NON	-CC	ONFO	RMANCE / UPD	ATE			AEROSPACE
QA Closed:		Date:							W	ork Order up	date only	
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
l					Rework	1		Skid-tube C	Crosstube		Water Jet	Engineering
Part No	э.				Scrap			—	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1		~ 	Finishing	4	re/Packaging	Other
NCR No	o				Suspected Unapproved			· -	omposite]	Supplier	
Root				Desc	ription of work order update	ı	nitial	Action		Sign &		
Cause	Di	ite Step	Qty	ļ	or non-conformance	Ch	ief Eng	Descripti	on	Date	Verification	QC Inspector
Design	_											
Doc/Data	_							:				
Equip/Tooling	_											
Handling/Pre	4											
Material	_					Ì						
Operator	_											
Offset/Setup	_											
Process	4											
Supplier	4										·	
Training	_	1										
Transport	_											
Unapproved				<u> </u>				<u> </u>				
	- 6					FA	ULI CA	TEGORY				
Landing	_	d:			General Bend		ارمانه اد)rogram		Outside Dim	ansiana F	Pressure/Forced
 	Ben	uing tre Not Conce	mtria	\vdash	BOM/Route	\vdash	Grain	Program	\vdash	Over/Under	<u> </u>	Set-up
-	Crac		munc	⊢	Broken/Damage/Defect	 	Hardwa	250		Part Incorred	<u> </u>	Temperature/Cure
 		rs p/Kink/Rippl	o/Mayo		Burrs	\vdash	₫	iie ion Incomplete/Unqua	alified	Part Lost/Mi		Weld
-	Cuff	• • • •	e, wave	-	Contamination	\vdash	1	tions Incomplete/Uncl	<u></u>	Part Moved	221118	⊣ i
-	_	s hing		-	Countersink	\vdash	4	gned/off center	eai –	Positioned V	L. Vrong	Wrong Stock Pulled
-		t Treat		\vdash	Cut Too Short		Mislabe	-	 	Power Loss/		Other
-	_	ection Strip ir	Tubo	\vdash	Drawing	\vdash	Misrea		<u> </u>	7, 0MEI 1022)	Juige _	Totalei
-		ks/Chatter	ilube	\vdash	Drill Holes	\vdash	Off-set					
	_	ning Sequence	.		Finish	-	4	Calibration				
		e/Twist in Tu		<u> </u>	Fit/Function	\vdash	4	Seguence				

5' 1 2

14.5.13

DQA:			Date:										
QA Closed:			Date:			WORK ORDER NON-	AEROSPACE						
an closed.			Dutc.						- :		ork Order up		<u> </u>
Work Orde	er: _					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part No.			Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			-4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other			
NCR N	۱o					Suspected Unapproved			Large Fab	Composite	j .	Supplier	
Root					Desci	ription of work order update	ı	nitial	Ac	ction	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved													
	l I		<u> </u>	l.	<u>I</u>	· · · · · · · · · · · · · · · · · · ·	FAI	JLT CAT	EGORY				
Landi		g Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread			Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Marks/Ch	natter			Drill Holes		Off-set					

Out of Calibration

Out of Sequence

Turning Sequence

Wave/Twist in Tube

Finish

Fit/Function

Picklist Print

5 · 💸

April-04-14 10:21:31 AM

Work Order ID: 115778

115778

Parent Item: D3403-5

Parent Item Name: Bushing

D3403-5

Start Date: 4/04/14

Required Date: 4/04/14

Page 1

Start Qty: 58.00

Required Qty: 58.00

Comments:

IPP REV:A NEW ISSUE 10-04-23 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No		100	f	52.6450	0.25	16			
M303R0 750 **										51	H-5-	12

303 Round Bar 0.750

Loc Code Location Loc Qty 52.645 MAT028 52.645 m127464

& 143

DQA:		Date:											27
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSP	ACE
				•	DISPOSITION			ACAING			·		
Work Orde	r:				DISPOSITION			AGAINS	ו טנ	PARTMENT,	PROCESS		
	Part No.				Rework	Skid-tube Crosstube			•]	Water Jet	Engineering	
Part N	0				Scrap			Machining Small Fat	·□	Pro	d. Eng. Coor.	Quality	
					Use-as-is		Thern	noforming Finishing	g	Rec/Sto	re/Packaging	Other	
NCR No				Suspected Unapproved		Large Fab Composit		-]	Supplier			
Root				Desci	ription of work order update		nitial	Action		Sign &			
Cause	Date	Step	Qty	ļ	or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspect	tor
Design													
Doc/Data													
quip/Tooling													
landling/Pre													
Material													
Operator													
Offset/Setup		1									!	Ì	
Process					i								
Supplier					•								
Training													
Transport						ļ							
Jnapproved			<u></u>	<u> </u>		<u> </u>							
						FA	ULT CA	TEGORY					
Landir	ng Gear				General		,			7	_		
	⊣			_	Bend		1	Program	<u> </u>	Outside Dim	-	Pressure/Force	d
	Centre N	ot Conce	ntric		BOM/Route		Grain		<u> </u>	Over/Under	-	Set-up	
ļ	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa		\vdash	Part Incorre	-	Temperature/C	ure
		nk/Ripple	e/Wave		Burrs		4 '	ion Incomplete/Unqualified	\perp	Part Lost/Mi	ssing	Weld	
ļ	_			-	Contamination	_	4	tions Incomplete/Unclear	<u> </u>	Part Moved	L	Wrong Stock Pu	ılled
				<u> </u>	Countersink	_	-	gned/off center	\vdash	Positioned V		¬	
				\vdash	Cut Too Short	_	Mislabe		L	Power Loss/	Surge	Other	
1	· ·	•	Tube	\vdash	Drawing	\vdash	Misrea						
				<u> </u>	Drill Holes	<u> </u>	Off-set						
	_			<u> </u>	Finish	_	4	Calibration					
	Date Step Qty ata Tooling Ing/Pre Ital Itor I/Setup Iss Ing			Fit/Function	1	Out of	Sequence						

DART AEROSPACE LTD	Work Order:	115778	
Description: Bushing	Part Number:	D3403-5	
Inspection Dwg: D3403 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+/-0.010	3HF.			11602	-12-10
Ø0.257	+0.010/-0.000	259			**	
0.060	`+/-0.005	.062			\-	
2.440	+0.010/-0.000	2445				
Ø0.313 x 60°	+/-0.010	214X/M			1	
Ø0.425	+0.000/-0.002	1423			mic	14
0.030 x 20°	+/-0.010	.03XQS				
R0.010	+/-0.010	,015				
			<u> </u>			
	·					
· · · · · · · · · · · · · · · · · · ·						

Measured by:

Date: 145-12

Date: 140-12

Date: 140-12

Date: 140-12

Date: 140-12

Date: 140-12

Date: 140-12

Rev	Date	Change	Revised by	Approved
Α	11.02.23	New Issue	KJ , ,	1,,
В	12.02.01	Dimension 2.440 was 2.500	KJ OK	W
			771	144

